

Work Order ID 137329

137329

Thursday, September 24, 2015 1:31:16 PM

Page 1

Item ID: 646.3001 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lower Cutter Assy **3**
 Start Date: 9/23/15 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 9/23/15 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: ML5 Date: SEP 25 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
646.3000	N/C

110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

120		0.00							
120									
Small Fab	Memo	0.05							
Small Fab	Assemble as per dwg and apply loctite 598 on all faying surfaces shown on dwg per note 7.								

A/R RTV LOCTITE 598: M133436
 exp. date: 04/17

3 15/12/17 986 9 DAS 36

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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137329

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Page 2

Item ID: 646.3001 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lower Cutter Assy
 Start Date: 9/23/15 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 9/23/15 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
130						(3)			
QC	Memo	0.01							

Quality Control

JAN 07 2016

140 Identify as per dwg & Stock Location: CCK018 0.00
140
 Packaging Memo 0.00
 Packaging ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***

3X DAS
28
0.00 JAN 08 2016

150 QC21- Final Inspection - Work Order Release 0.00
150
 QC Memo 0.00
 Quality Control

MLJ JAN 08 2016

MLJ JAN 08 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
☐ OTHER : _____					

Picklist Print

Thursday, September 24, 2015 1:31:15 PM

Page 1

Work Order ID: 137329

137329

Parent Item: 646.3001

646.3001

Parent Item Name: Lower Cutter Assy

Start Date: 9/23/15

Required Date: 9/23/15

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 12.10.19 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS21042L08		Purchased	No				Each	812.0000		76 57			
MS21042L 08									**				
Nut													

Location	Loc Qty	Loc Code
CA	101	
m129682	101	
GA	300	
m133134	300	
ST304	411	
123900	16	
m128401	102	
m128429	3	
m131317	62	
m132930	228	

646.3010

Manufactured No

110

Each

0.0000

1

646.3010

LH Half

646.3011

Manufactured No

110

Each

9.0000

1

646.3011

RH Half

Location	Loc Qty	Loc Code
cck102	9	
126778	9	

DEC 17 2015

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
☐ OTHER : _____					

Picklist Print

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Page 2

Work Order ID: 137329

137329

Parent Item: 646.3001

646.3001

Parent Item Name: Lower Cutter Assy

Start Date: 9/23/15

Required Date: 9/23/15

Start Qty: 4.00

Required Qty: 4.00

646.3012 Manufactured No

110 Each 6.0000 1

646.3012

Lower Guide

**

43

DAS
6
9-89

Location

Loc Qty

Loc Code

MF

6

128426

4

130736

2

646.3013 Manufactured No

110 Each 3.0000 1

646.3013

Blade

**

43

DAS
6
9-89

Location

Loc Qty

Loc Code

cck103

3

127805

3

646.3014 Manufactured No

110 Each 0.0000 1

646.3014

Blade

**

43

136/76

DAS
6
9-89

646.3015 Manufactured No

110 Each 0.0000 1

646.3015

Blade

**

43

136216 x1
138372 x2
7657

DAS
6
9-89

MS27039-08-19 Purchased No

110 Each 562.0000 19

MS27039-08-19

Screw

**

15/12/17

DAS
36
9-89

Location

Loc Qty

Loc Code

GA

250

m132930

250

ST260a

100

m133077

100

ST273A

183

m131317

183

ST281

29

m131264

29

7

M133483
(50x)

Thursday, September 24, 2015 1:31:16 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Page 3

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137329

Parent Item: 646.3001

646.3001

Parent Item Name: Lower Cutter Assy

Start Date: 9/23/15

Required Date: 9/23/15

Start Qty: 4.00

Required Qty: 4.00

NAS1149FN832P

Purchased

No

110

Each

1,949.000

38

~~152~~ 114

DAS
36
9-89

NAS1149FN832P

Washer

**

15/12/17

Location

Loc Qty

Loc Code

GA

737

125268

737

ST260a

291

125268

291

st268

921

M130388

921

M133769
114x

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

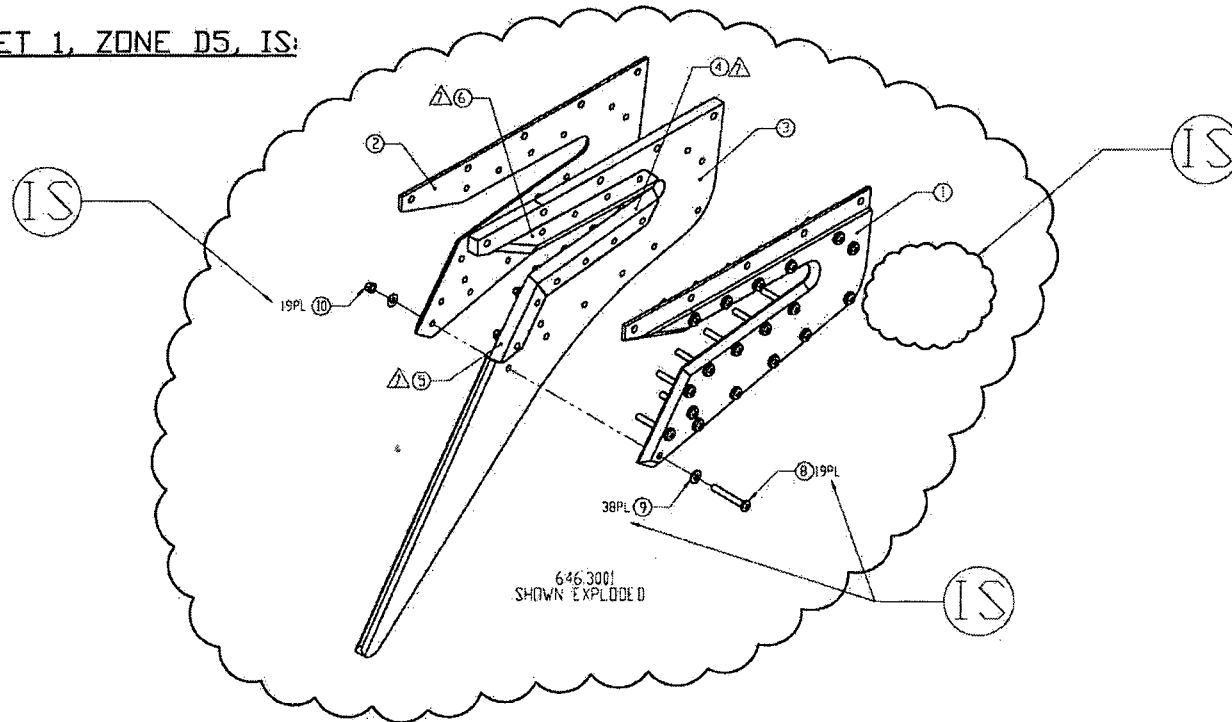
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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OTHER : ☐																																																															

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 02195		SHEET 1 OF 4	
	DWG NO. 646.3000	REV: N/C	PREPARED BY S. HUFF	DATE: 01/05/09
	EFFECT ON DWG ☐ INC. ☒ UNINC.			
	DWG TITLE: LOWER CUTTER ASSY			
APPROVED BY: ENGR <i>[Signature]</i>		MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: NEXT ORDER
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE		REASON: REMOVED RIVETS IN FAVOR OF ADDITIONAL SCREWS		

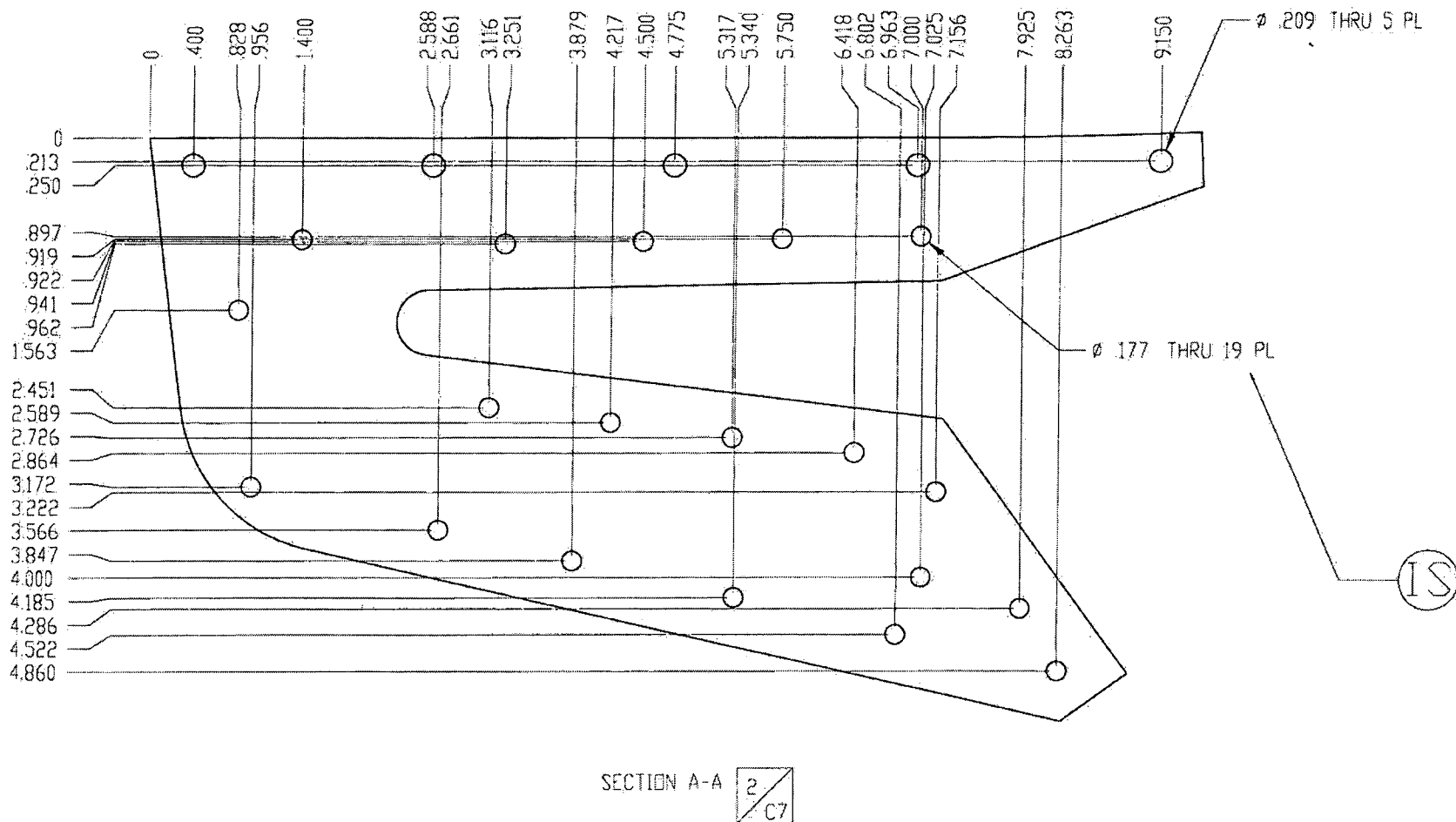
SHEET 1, ZONE D5, IS:



137329 MLS
15-09-25

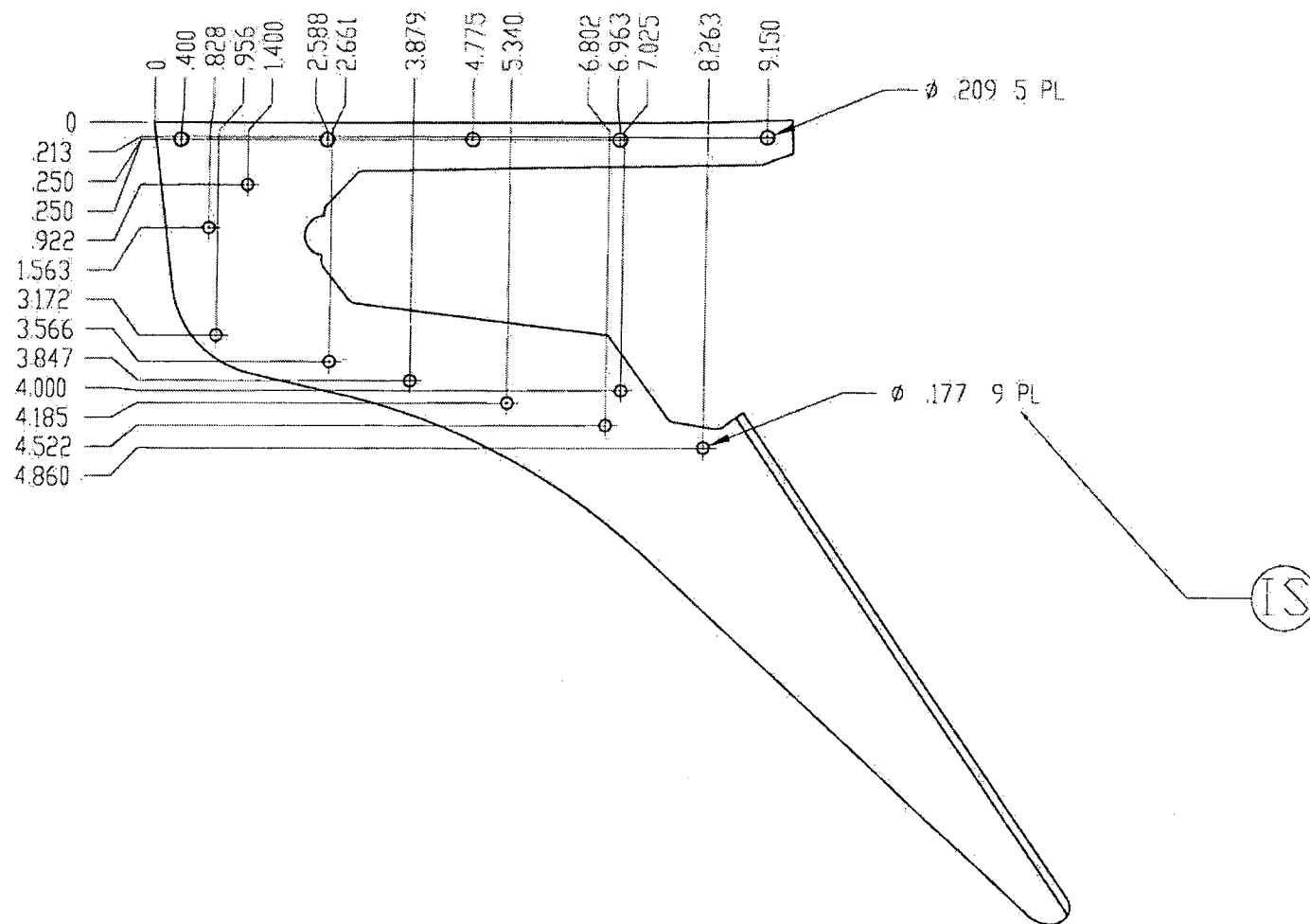
10	R	601.1541	19	LOCKNUT	MS21042L08
9	R	601.2764	38	WASHER	NAS1149FN832P
8	R	601.2765	19	SCREW	MS27039-0819
7	D	601.2766	2	RIVET	MS20470AD5-18
			.3001		
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION
DOCUMENTS EFFECTED:				☐ MDL ☒ INSTALL INSTRUC ☒ ICA ☐ FMS ☒ BOM	CHANGE CATEGORY ☐ MAJOR ☒ MINOR
				DER REVIEW REQUIRED ☐ YES ☒ NO	

SHEET 3 IS:



F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION

SHEET 5 IS:

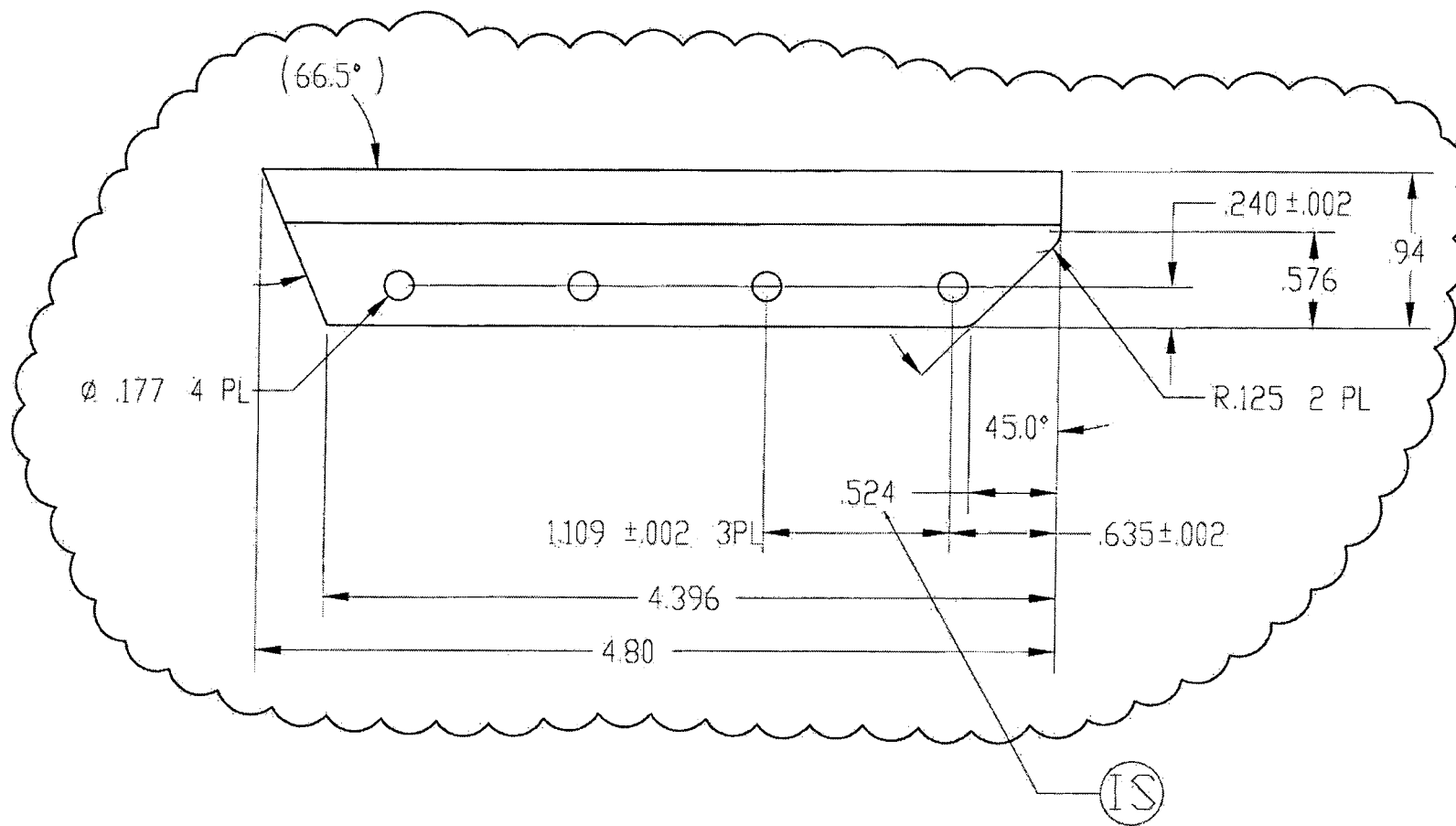


SECTION F-F



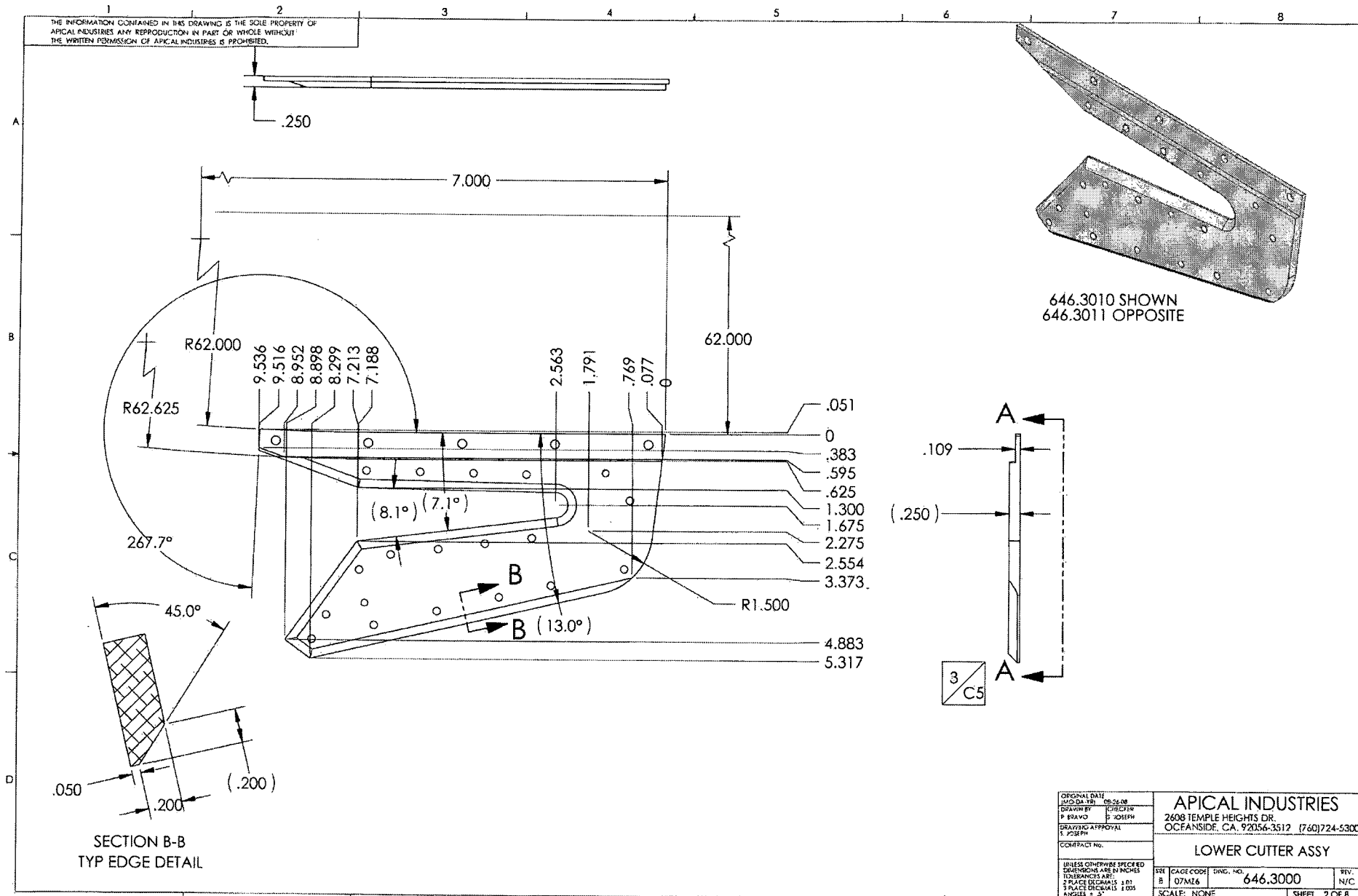
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION

SHEET 6, ZONE C4, IS:



F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION

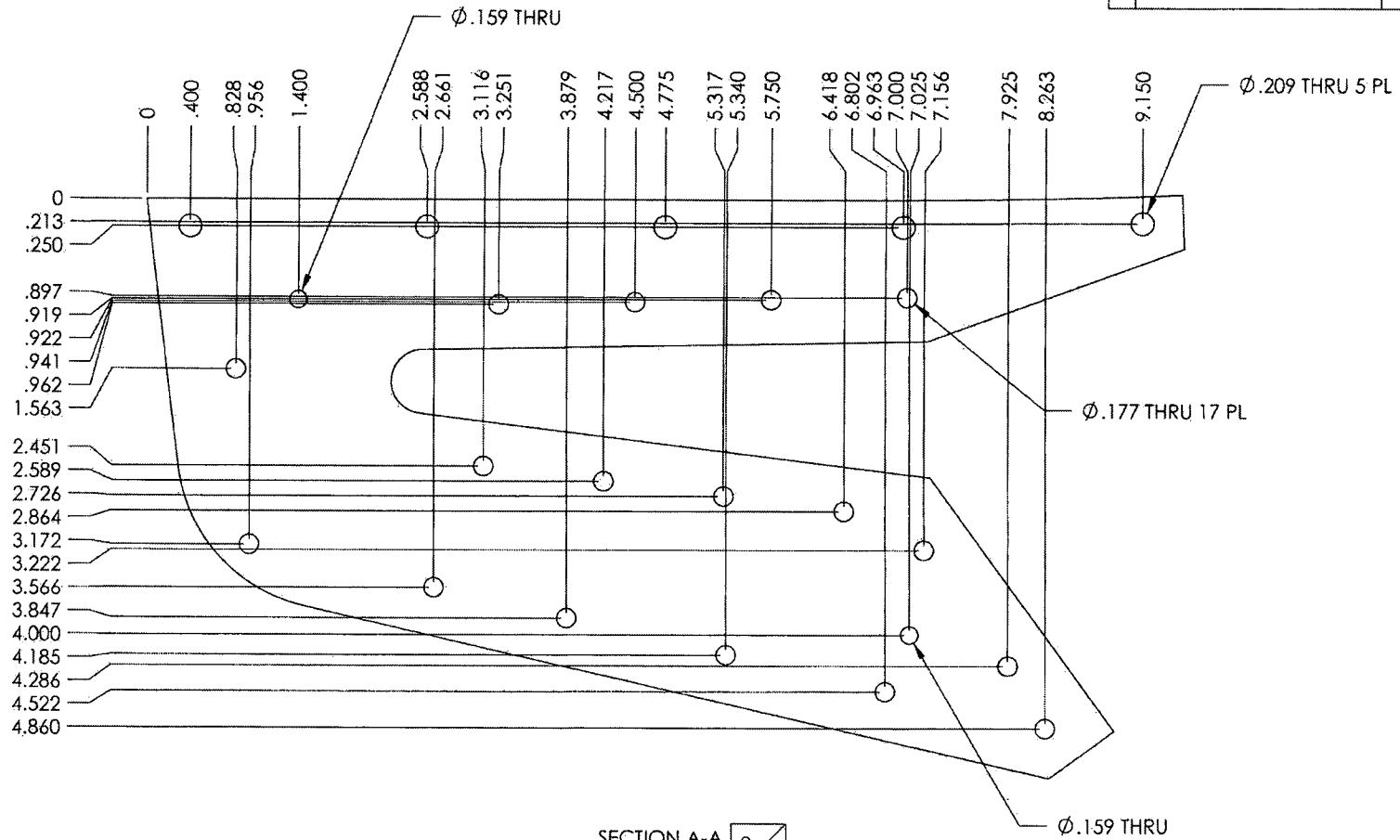
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ORIGINAL DATE 10/01/88		APICAL INDUSTRIES	
DRAWN BY P. BRAVO		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL S. JOSEPH		LOWER CUTTER ASSY	
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .001 ANGLES ± .5°		REV. NO. 07/ML6	REV. N/C
SCALE: NONE		DWG. NO. 646.3000	SHEET 2 OF 8

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REVISION			
REV.	DESCRIPTION	DATE	APPROVED

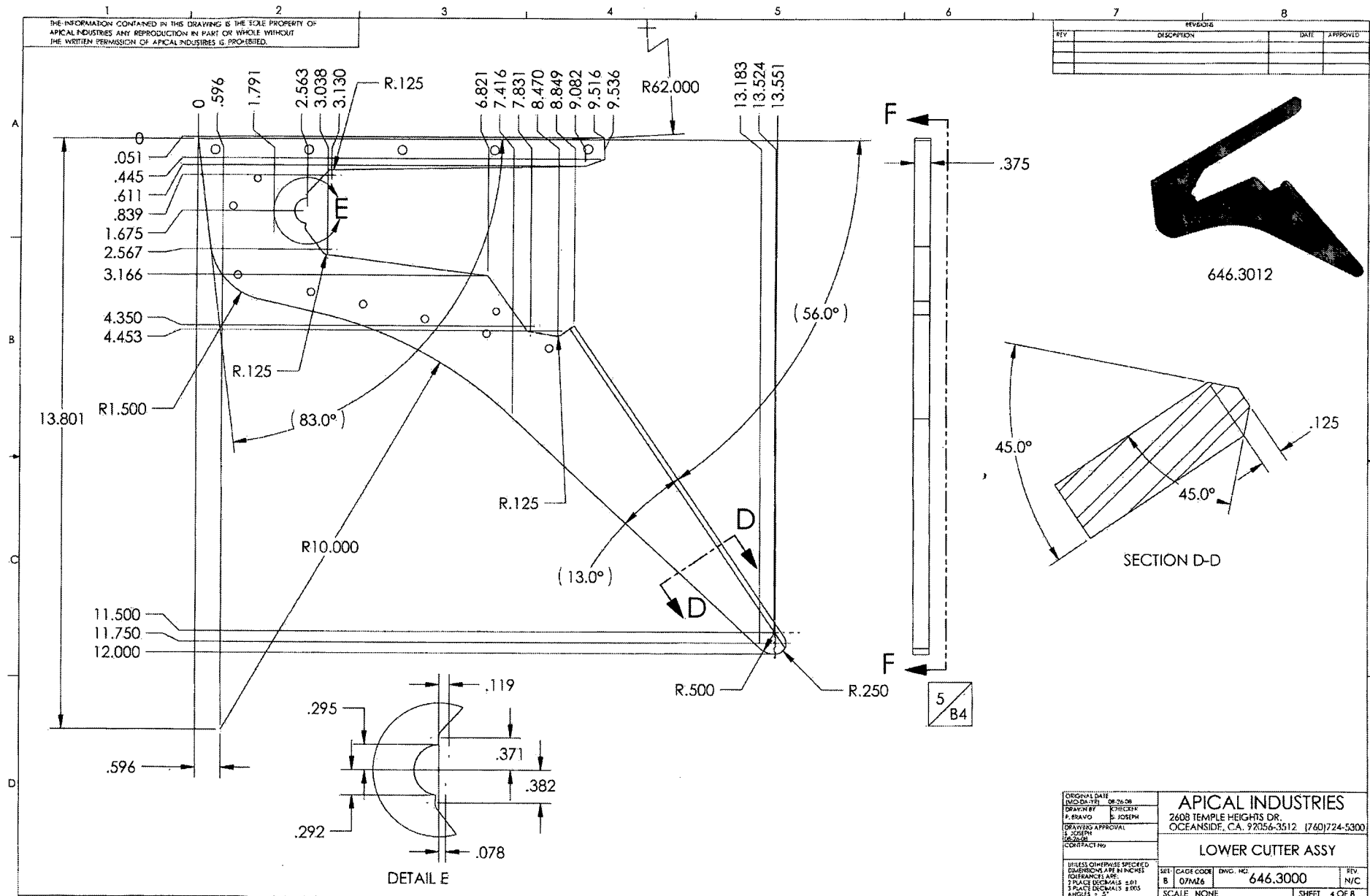


SECTION A-A $\frac{2}{C7}$

OPERATOR DATE JMD DA VIN 08-26-08 DRAWN BY P. BRAVO S. JOSEPH DRAWING APPROVAL S. JOSEPH 08-26-08 CONTRACT NO.		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .01$ 3 PLACE DECIMALS $\pm .005$ ANGLES $\pm .5^\circ$		SET B 07/02/08	DWG. NO. 646.3000 SCALE NONE
		REV. N/C	SHEET 3 OF 6

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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



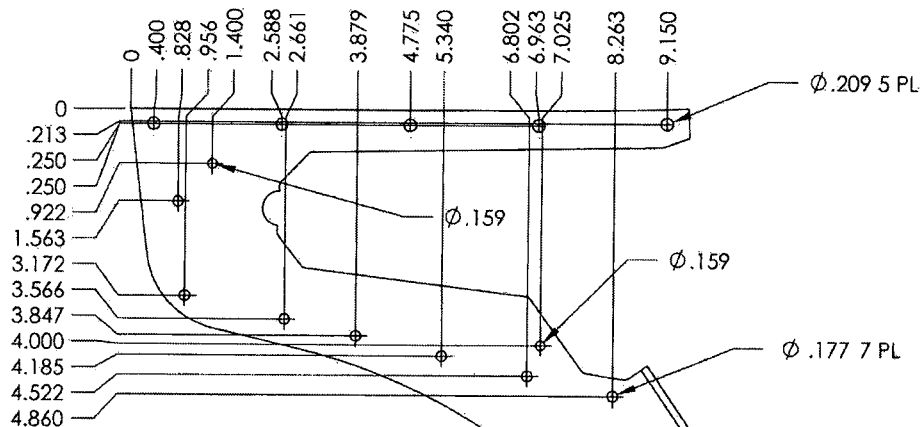
ORIGINAL DATE
 06/26/88
 DESIGNED BY
 F. BRAVO
 DRAWN BY
 J. JOSEPH
 CHECKED BY
 J. JOSEPH
 CONTRACT NO.

UNLESS OTHERWISE SPECIFIED
 DIMENSIONS ARE IN INCHES
 TOLERANCES ARE:
 3 PLACE DECIMALS ± .01
 2 PLACE DECIMALS ± .005
 ANGLES ± .5°

APICAL INDUSTRIES
 2608 TEMPLE HEIGHTS DR.
 OCEANSIDE, CA. 92056-3512 (760) 724-5300
LOWER CUTTER ASSY
 SET / CADS CODE / DWG. NO. / REV.
 B / 07M26 / 646.3000 / N/C
 SCALE: NONE / SHEET 4 OF 8

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED

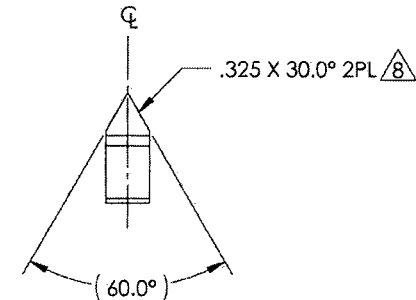
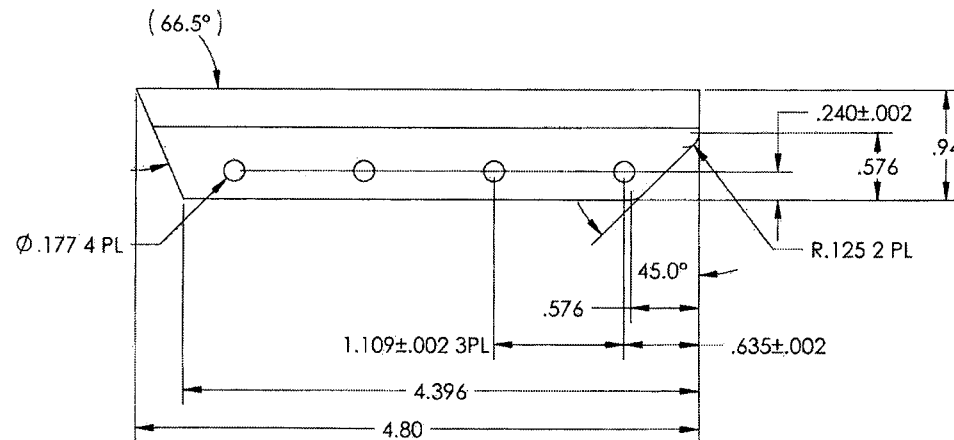
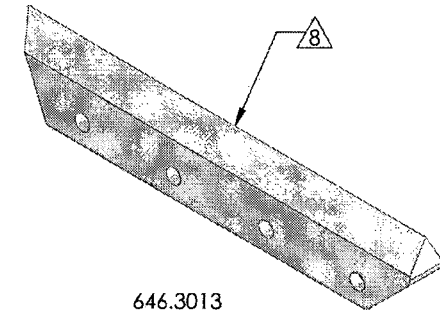


SECTION F-F 4
B6

ORIGINAL DATE (MM-DD-YY) 08-24-05		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWN BY P. BRAYO	CHECKED J. JOSEPH		
DRAWING APPROVAL E. JOSEPH		LOWER CUTTER ASSY	
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.010 ANGLES ±.2°		REV. N/C	
SCALE NONE		DWG. NO. 646.3000	SHEET 5 OF 8

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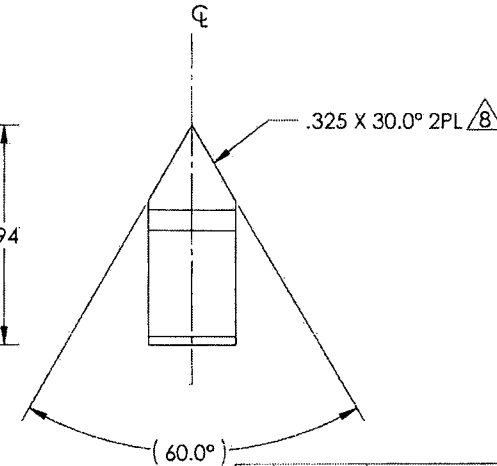
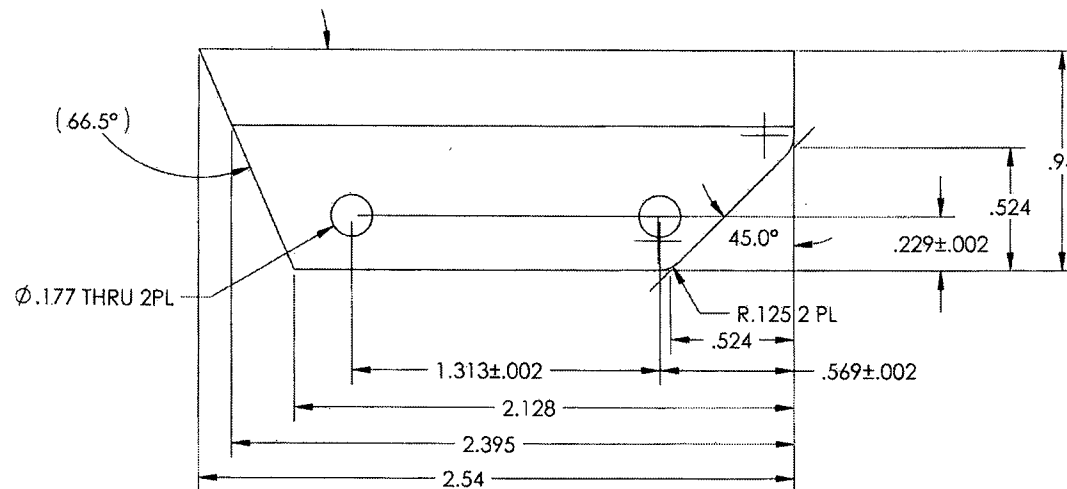
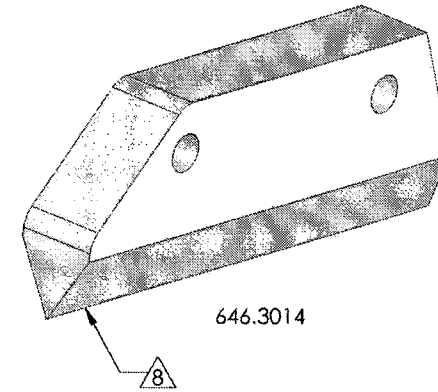
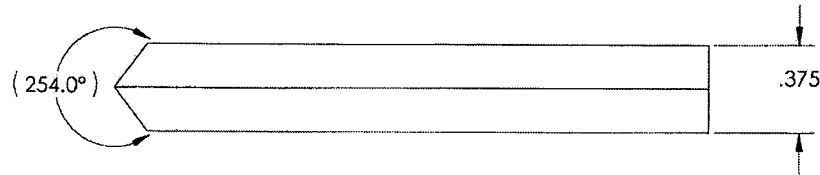
REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



ORIGINAL DATE 10/24/11		APICAL INDUSTRIES	
DRAWN BY P. MAVO		2608 TEMPLE HEIGHTS DR.	
CHECKED BY S. JOSEPH		OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL S. JOSEPH		LOWER CUTTER ASSY	
CONTRACT NO.		646.3000	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS $\pm .01$ ANGLES $\pm .5^\circ$		SHEET 6 OF 8	REV. N/C

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



ORIGINAL DATE: 05-24-98
 DRAWN BY: P. BRAY
 CHECKED BY: S. JOSEPH
 DRAWING APPROVAL: S. JOSEPH
 CONTRACT NO.

UNLESS OTHERWISE SPECIFIED
 DIMENSIONS ARE IN INCHES
 DECIMALS ARE:
 3 PLACE DECIMALS .001
 ANGLES ± .5°

APICAL INDUSTRIES
 2608 TEMPLE HEIGHTS DR.
 OCEANSIDE, CA. 92056-3512 (760)724-5300

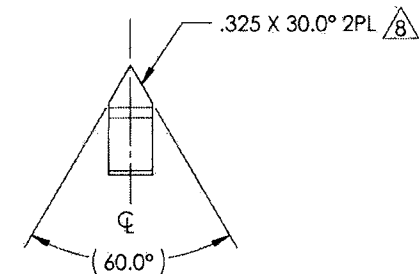
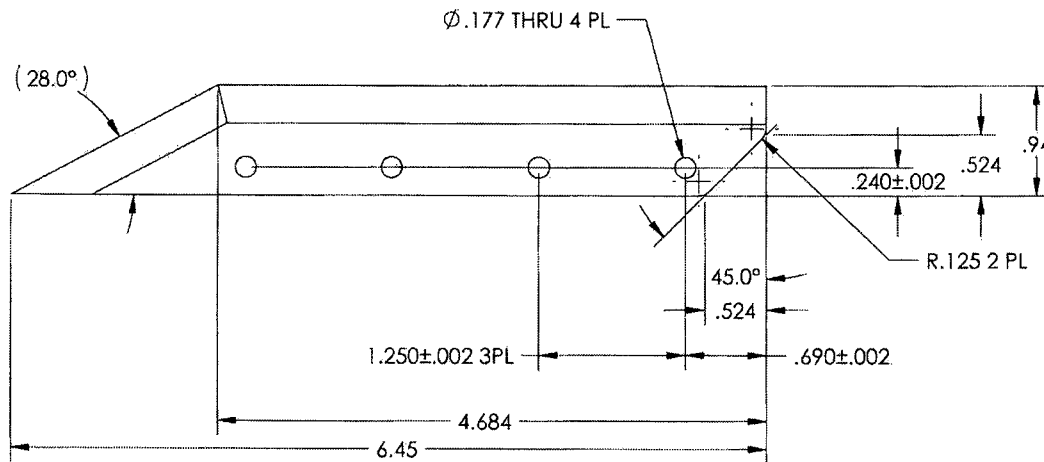
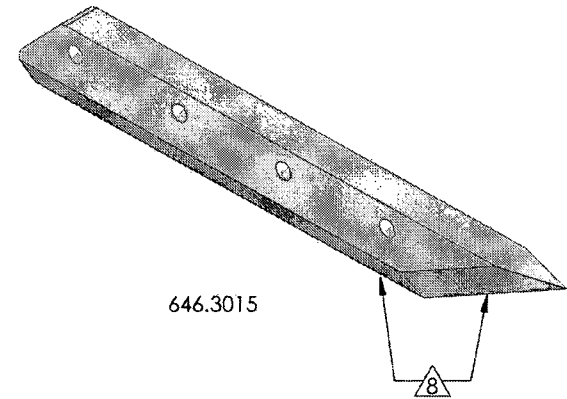
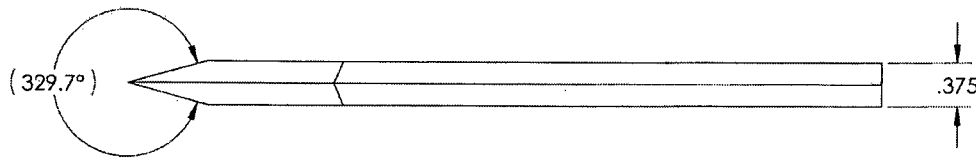
LOWER CUTTER ASSY

SHEET	CAGE CODE	DWG. NO.	REV.
B	07M26	646.3000	N/C

SCALE: NONE SHEET 7 OF 8

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



ORIGINAL DATE 10-26-98		APICAL INDUSTRIES	
DRAWN BY: J. JOSEPH		2608 TEMPLE HEIGHTS DR.	
CHECKED BY: J. JOSEPH		OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL		LOWER CUTTER ASSY	
CONTRACT NO.		SHEET 8 OF 8	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SEE CASE CODE B 07M26	REV N/C
SCALE NONE		QTY NO. 646.3000	